

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017299**Date Inspected:** 01-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

CWI Inspectors: ZPMC: Mr. Liu Hua Jie, Ms. Yu Dong Ping

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

**OBG Segment Trial Assembly**

CWI Mr. Liu Hua Jie informed this QA Inspector that no ZPMC personnel were performing welding on OBG segments in the trial assembly areas.

**Bay 11**

This QA Inspector observed ZPMC welder Mr. Zhong Cheng, stencil 041271 used shielded metal arc procedure WPS-345-SMAW-3G(3F)-Repair to make repair weld ESD1-TL5-2B/F-2A/B. ZPMC CWI Ms. Yu Dong Ping informed this QA Inspector that this work is being performed in accordance with weld repair document T-WR3691. This weld was located on an east tower lift 5 internal connection plate. This QA Inspector observed ZPMC has electric heating elements to preheat and maintain the base material temperature during this welding. This QA Inspector measured a welding current of approximately 160 amps and Mr. Zhong Cheng appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

documents.

This QA Inspector observed ZPMC welder Mr. Li Ming Qian stencil 054460 used shielded metal arc procedure WPS-345-SMAW-3G(3F)-Repair to make repair weld ESD1-TL5-2B/F-8A/B. ZPMC CWI Ms. Yu Dong Ping informed this QA Inspector that this work is being performed in accordance with weld repair document T-WR3692. This weld was located on an east tower lift 5 internal connection plate. This QA Inspector observed ZPMC has electric heating elements to preheat and maintain the base material temperature during this welding. This QA Inspector measured a welding current of approximately 160 amps and Mr. Li Ming Qian appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Zhao Guiting, stencil 040723 used shielded metal arc procedure WPS-345-SMAW-3G(3F)-Repair to make repair weld ESD1-TL5-2B/F-7A/B. ZPMC CWI Ms. Yu Dong Ping informed this QA Inspector that this work is being performed in accordance with weld repair document T-WR3693. This weld was located on an east tower lift 5 internal connection plate. This QA Inspector observed ZPMC has electric heating elements to preheat and maintain the base material temperature during this welding. This QA Inspector measured a welding current of approximately 160 amps and Mr. Zhao Guiting appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

See Above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Dawson,Paul
<b>Reviewed By:</b>	Carreon,Albert

---

Quality Assurance Inspector
QA Reviewer

---